



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4669-1

Job Sheet 167136



Part No: D4669-1

Job Qty: 60 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	60 Ea		11/9/17	0.00	0.00	Start Up Waterjet1	SC
100	Waterjet	60 pcs		11/9/17	0.00	1.86	Waterjet1	DAS SC
120	QC	60 pcs		11/9/17	0.00	0.00	QC8	38
130	Brake NC	60 pcs		11/9/17	0.01	10.89	Brake NC 1	SS 10.89
140	QC	60 pcs		11/9/17	0.00	0.00	QC5	dk 17-12-21
150	HandFinish	60 pcs		11/10/17	0.00	1.13	HandFinish1	2017-12-22
160	QC	60 pcs		11/10/17	0.00	0.00	QC7	DEC 22 2017
170	Packaging	60 pcs		11/10/17	0.00	0.00	Packaging3	DEC 22 2017
180	QC21-SA	60 Ea		11/10/17	0.00	0.00	QC21	DAS 21

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.032	3	119	0	0
	135724	4.6			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
2	Bracket	0.640Inches ± 0.030	0.670 0.610		
3	Bracket	0.940Inches ± 0.030	0.970 0.910		
4	Bracket	1.160Inches ± 0.030	1.190 1.130		
5	Bracket	2.320Inches ± 0.030	2.350 2.290		
6	Bracket	2.840Inches ± 0.030	2.870 2.810		
7	Bracket	3.480Inches ± 0.030	3.510 3.450		
8	Bracket	2.540Inches ± 0.030	2.570 2.510		
9	Bracket	1.320Inches ± 0.010	1.330 1.310		
10	Bracket	0.440Inches ± 0.010	0.450		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Sk Ma Thermof Lar QT
Part No. _____		
NCR No. _____		
Date : _____		
Step #: _____		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Description Work Order Deviation

Root Cause			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature
Design ☐	☐ Operator	☐ Bending	☐ Set-up
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Inc
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes
Past Expiry Date ☐	☐ Manufacturing Process		
Misidentified ☐	☐ Past Due		
OTHER : _____			

Bracket

D4669 - 1

PART NO:
Revision:
Operation:
Change No:

Mfg Date: 11/14/17
Job No: 167136

Reengineering ☐
Quality ☐
Other ☐
042) Approval

Initiated By

/ Supervisor
Verification

Coordinator
Approval

Drawn Wrong
Dimensions
Clearance tolerance
Incorrect
Missing
Lead

Drawing
Finish
Misread
Turning Sequence

				0.430
11	Bracket	0.220Inches ± 0.010	0.230 0.210	
12	Bracket	0.032Inches ± 0.010	0.042 0.022	
13	Bracket	0.320Inches ± 0.030	0.350 0.290	
14	Bracket	1.520Inches ± 0.030	1.550 1.490	
15	Bracket	1.840Inches ± 0.030	1.870 1.810	
16	Bracket	2.180Inches ± 0.030	2.210 2.150	

Plex 10/25/17 8:22 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

